

Work Order ID 70087

Thursday, May 26, 2011 12:40:43 PM



Page 1

Item ID: D206-628-034

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step RH

Stop



Start Date: 5/27/2011 Start Qty: 1.00

Required Date: 5/27/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date:

Tooling:

QC:

Date:

SPC (Y/N):

Date:

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-034 CHG 002

CHG 002

Sub 61

for CL 11-6-1

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/6/31

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sub 61

*TH
RHC*

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ONT CANADA K6A 1K7		TC APPROVAL # 09-09 TEL: 1-613-632-5200	
P/N	D206-628-033	CHG	CHG003
DESC	Heli-Access-Step LH	SIC	SH198-14
LOT	B68111	SIC	SA00300SE
MODEL	B-11407	SIC	
PATENTS US #5735484 CA #2222183 EUROPEAN No. #0828655		MADE IN CANADA 02720-2	

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Item ID: D206-628-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH

Start Date: 5/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-628-034

Location:

PPP Rev:

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/6/11 SP

11/6/13 J
MF
11-06-02

Picklist Print

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Work Order ID: 70087

Parent Item: D206-628-034

Parent Item Name: Heli-Access-Step RH



Start Date: 5/27/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN3C4A Purchased No

110 Each 2,467.000

3 3



BOLT

Location	Loc Qty	Loc Code
ST350	2467	
117094	955	
117313	212	
117688	800	
117795	500	

AN4C14A Purchased No

110 Each 62.0000

8 8



Bolt

Location	Loc Qty	Loc Code
ST337	40	
117688	40	
ST357	22	
117366	22	

AN4C15A Purchased No

110 Each 133.0000

4 4



Bolt

Location	Loc Qty	Loc Code
ST358	133	
115835	25	
115936	10	
117441	48	
117795	50	

M112314

M110155

M111359

Picklist Print

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Work Order ID: 70087

Parent Item: D206-628-034

Parent Item Name: Heli-Access-Step RH

Start Date: 5/27/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10 NAS1149C0363 Purchased No

110 Each 0.0000 3 3



WASHER

AN960C416L Purchased No

110 Each 0.0000 24 24



WASHER

D2731-3 Manufactured No

110 Each 100.0000 4 4



Mounting Lug

Location

Loc Qty

Loc Code

ST469 100
47967 61
52329 39

D2732 Manufactured No

110 f 256.3281 2 2



Rubber Extrusion

Location

Loc Qty

Loc Code

ST410 256.32811
64283 256.32811

D2842-042 Manufactured No

110 Each 0.0000 1 1



Step Assembly RH 206 Float

D2844-1 Manufactured No

110 Each 11.0000 2 2



Arm

Location

Loc Qty

Loc Code

ST265 11
62954 11

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Shop Packet Print

Page 2

M111879

M111808

B47967

B43118

B 61045

B50824 11/5/31 62954

3.00" long
D2842-042
Step Assembly RH 206 Float
D2844-1
Arm

8

8

Step-kit
measured
5/16/11

Picklist Print

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Parent Item: D206-628-034

Parent Item Name: Heli-Access-Step RH

Start Date: 5/27/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

D2844-3

Manufactured No

110 Each

16.0000



1
B46 845 D

Arm

Location

Loc Qty

Loc Code

ST265

4

62967

4

ST266

12

66822

12

D3394-041

Manufactured No

110 Each

63.0000



4
B47970 D

Lug Assembly

Location

Loc Qty

Loc Code

MEZZ

23

56528

23

ST474

40

68257

40

MS21043-4

Purchased No

110 Each

1,718.000



12
M112243 11/5/11 D

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

576

117423

576

ST301

1102

114784

48

115936

40

116549

14

117601

500

117793

500

Picklist Print

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Work Order ID: 70087

Parent Item: D206-628-034

Parent Item Name: Heli-Access-Step RH



Start Date: 5/27/2011

Required Date: 5/27/2011

Start Qty: 1.00

Required Qty: 1.00

8 NAS1515H3

Washer

Purchased

No

110

Each

148.0000

3

3



M111268 S

Location

Loc Qty

Loc Code

ST277

148

116373

48

117460

100

S NAS1515H4L

WASHER

Purchased

No

110

Each

238.0000

24

24



M111359 S 11/6/31

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

198

117363

198

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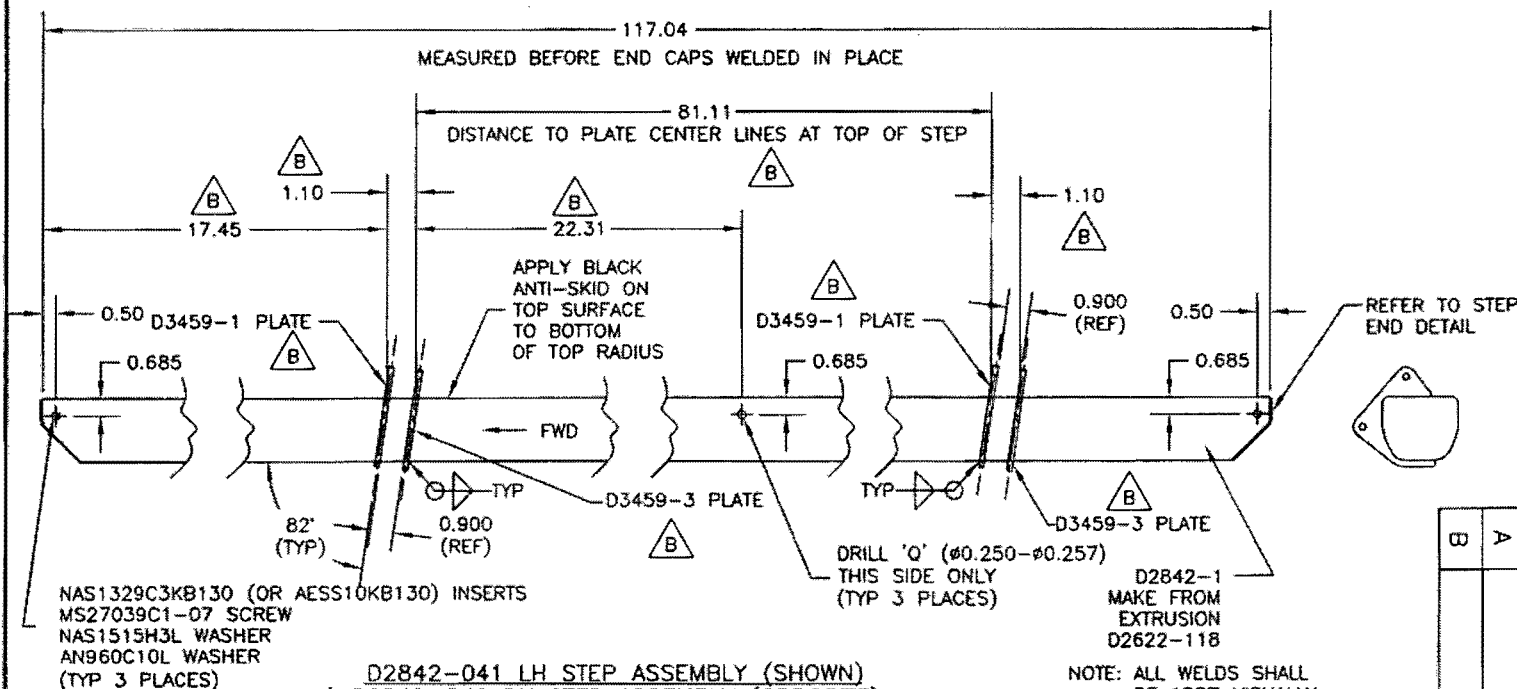
5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	AN960C10	WASHER
24	24	24	24	24	24	AN960C416L	WASHER
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE



DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	REV. B
			206L/407 FLOAT STEP ASSEMBLY	SHEET 1 OF 1
			NEW ISSUE	SCALE
			RE-DESIGN, ADD D3459-1/-3	NTS

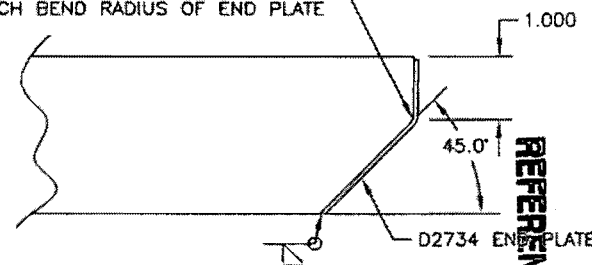


D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.14